

Date: Monday, 05/05/2008 11:11:48 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARMREST WELDMENT
Job Number	: 39031	Part Number	: D3785041
Estimate Number	: 13297	Drawing Number	: D3785 PRELIM
P.O. Number	:	Project Number	: N/A
This Issue	: 05/05/2008	Drawing Revision	: PRELIM 08.05.21 08.06.09
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 08/05/2008 Qty: 1 Um: Each
Previous Run	:		
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:A 08-05-01 new issue DD verified by:EC		FOR ENGINEERING USE ONLY

Additional Product

PROTOTYPE ~~PRELIMINARY ISSUE~~

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
2.0	D37851	Tube
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Tube batch: <u>339032</u>		
3.0	D37853	Bracket
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket batch: <u>339033</u>		
4.0	D37855	Fixture
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fixture batch: <u>339034</u>		

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld as per dwg D3785 per QSI004
 24.1 MS21209F615 Qty: 1 Heli-coil Batch: N/A ACCEPTABLE TO USE non-locking HELI-COIL 08.05.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/22		Scrap due to material chg S.S. to Alum 6061T6	/	Scrap and destroy welded ass'y Reduce with new material chg	08/05/22	/	08/05/22	08/05/22
		→ Sub w/o's only		- Replace on this w/o Qty 1 XXXXXXXXXX				

NOTE: Date & initial all entries

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Drawing Name: ARMREST WELDMENT

Job Number: 39031

Part Number: D3785041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/08/05/27 Q1

7.0 QC5

INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL



08.05.27

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock _____

Location: _____

N/A

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/08.06.05 Prototype

Job Completion



~~DEFINITIVE RECALL~~
~~RELEASED 08.05.27 AUTH 4~~
~~RELEASED 08.05.27 DATE 4~~

Initial Setup/Install

→ 7.1 Small Fab
1- Tap hole For 3/8"-24 heli-coil as per drawing A3785
2- install heli-coil in A3785-5 Fixture as per
drawing A3785

JK 080527

7.2 QC5

08.05.27

MF 08-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By:

8.04.30

Design Manager Approval:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

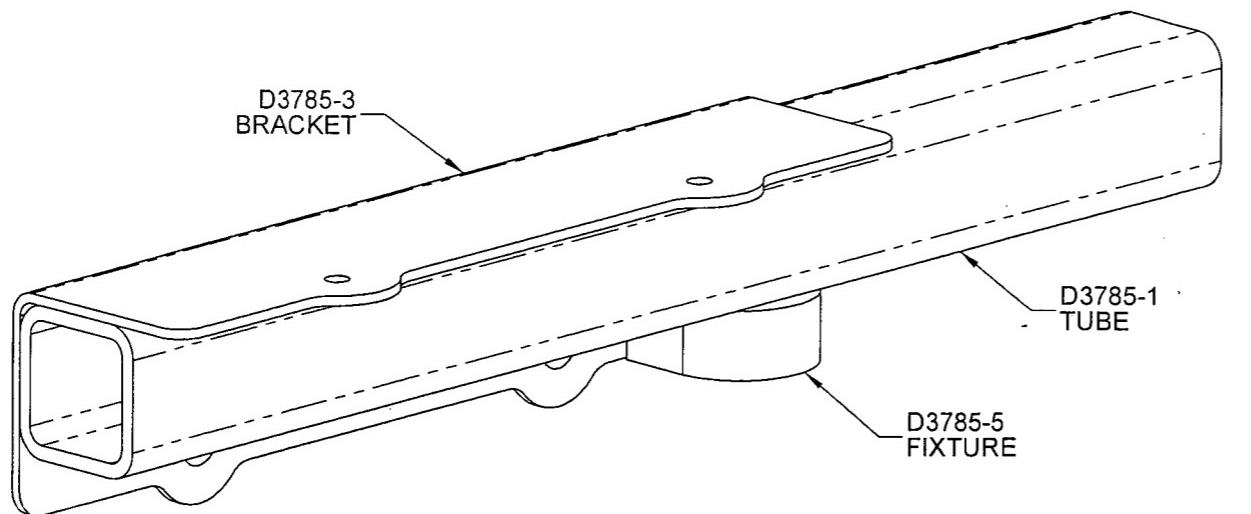
Requested By: [Signature]

Design Manager Approval: [Signature]

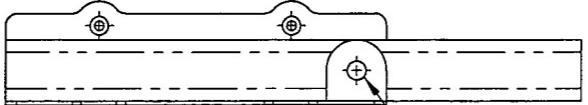
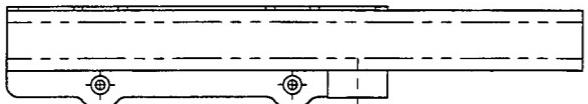
Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
5	D3701-1F	FLOOR DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3702-1	FORWARD DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-1F	AFT DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-3F	AFT CORNER DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-5	AFT CAP	08.04.30	Y	08.05.02	FOR TESTING	
1	D3785-041	ARMREST WELDMENT	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3785-1	TUBE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-3	BRACKET	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-5	Fixture	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	

8 7 6 5 4 3 2 1

QTY	P/N	DESCRIPTION
-041		
X	D3785-041	ARMREST WELDMENT
1	D3785-1	TUBE
1	D3785-3	BRACKET
1	D3785-5	Fixture
1	MS21209F6-15	HELI-COIL, SCREW LOCKING (RED)



D3785-041 ARMREST WELDMENT



INSTALL MS21209F6-15
HELI-COIL INSERT

PROTOTYPE

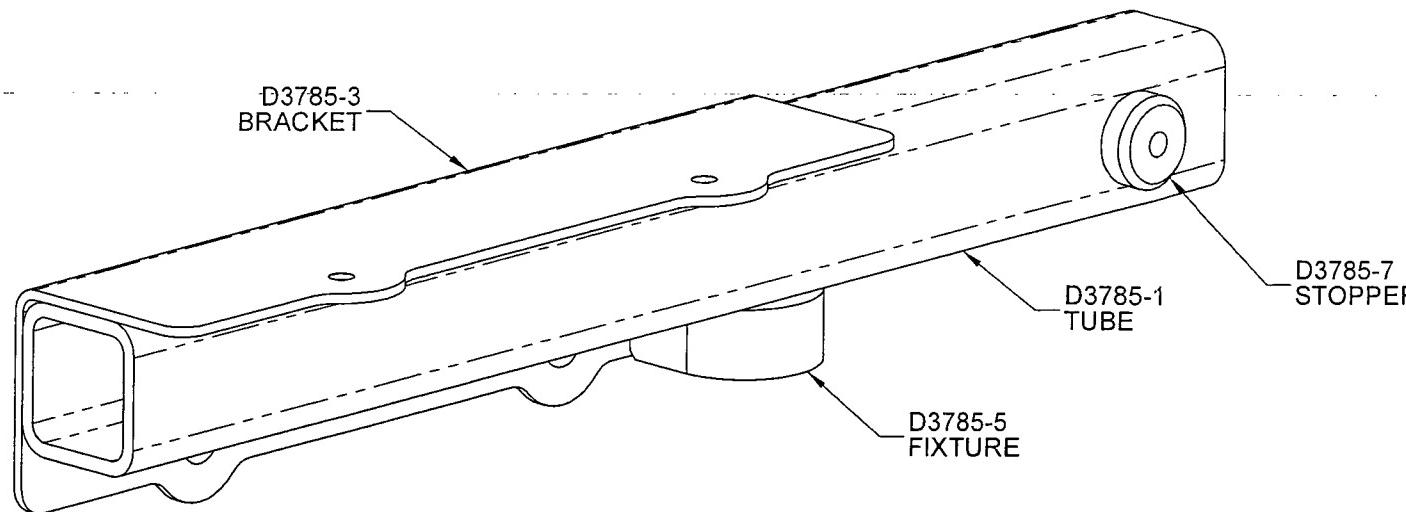
PRELIMINARY ISSUE

106.05.21

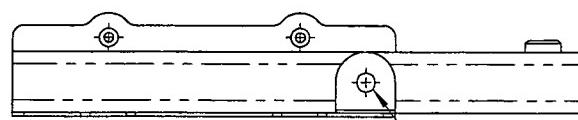
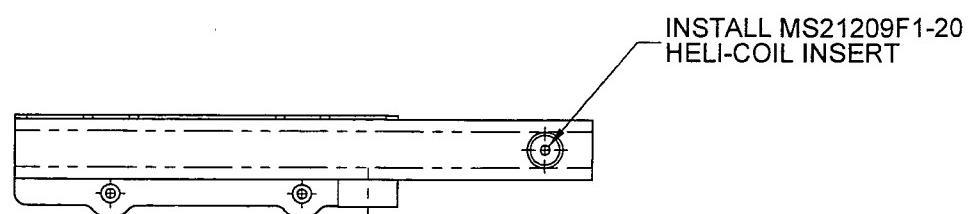
A	NEW ISSUE	MB	08.04.29
REV.		BY	DATE
DESIGN			
DRAWN			
CHECKED		DRAWING NO.	
MFG. APPR.		D3785	REV. A
APPROVED		TITLE	SHEET 1 OF 4
DE APPR.		ARMREST WELDMENT	NTS
DATE	08.04.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

QTY -041	P/N	DESCRIPTION
X	D3785-041	ARMREST WELDMENT
1	D3785-1	TUBE
1	D3785-3	BRACKET
1	D3785-5	FIXTURE
1	D3785-7	STOPPER
1	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
1	MS21209F6-15	HELI-COIL, SCREW LOCKING (RED)



D3785-041 ARMREST WELDMENT



INSTALL MS21209F6-15
HELI-COIL INSERT

PROTOTYPE
PLEASE RETURN ALL INFORMATION
DATA TO ENGINEER

06.06.07

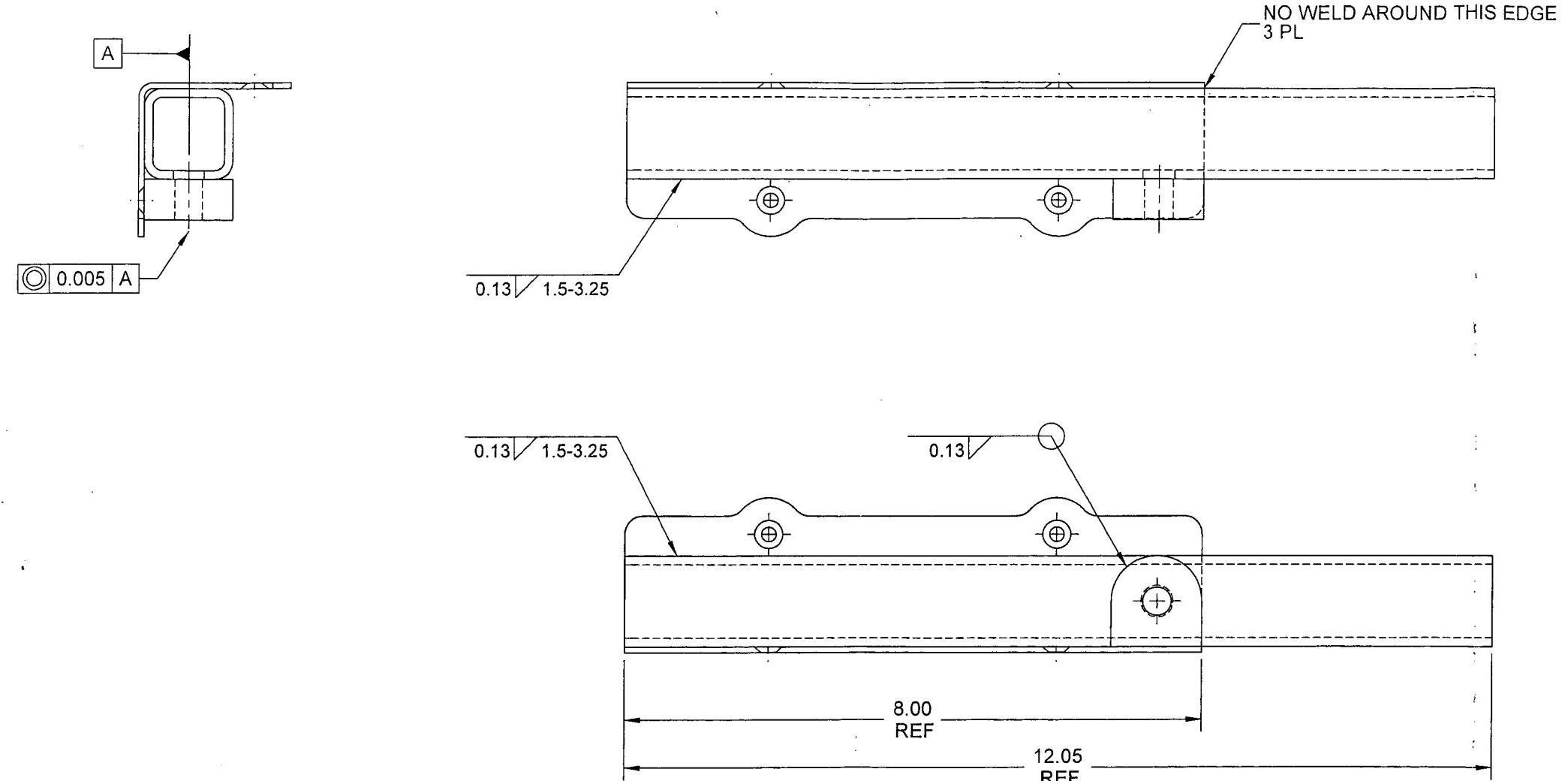
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REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[initials]</i>	DART AEROSPACE LTD	
DRAWN	<i>[initials]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[initials]</i>	D3785	SHEET 1 OF 4
APPROVED	<i>[initials]</i>	TITLE	SCALE
DE APPR.	<i>[initials]</i>	ARMREST WELDMENT	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

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D3785-041 ARMREST WELDMENT WELDING DETAIL

PROTOTYPE

~~PRELIMINARY ISSUE~~
108-05-21

D3785-041 NOTES:

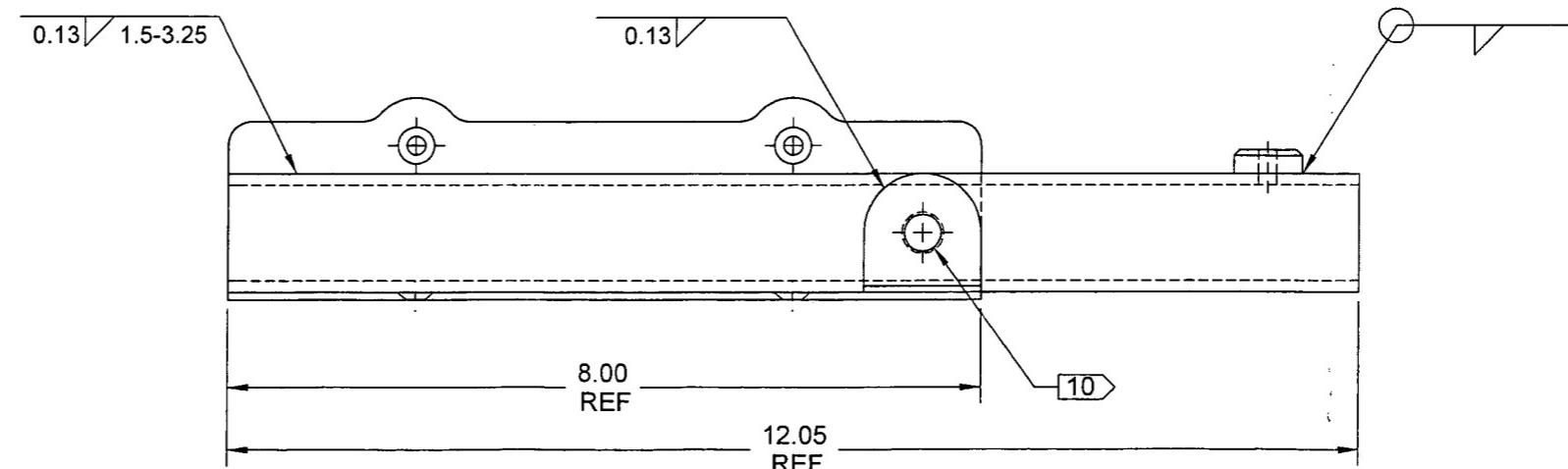
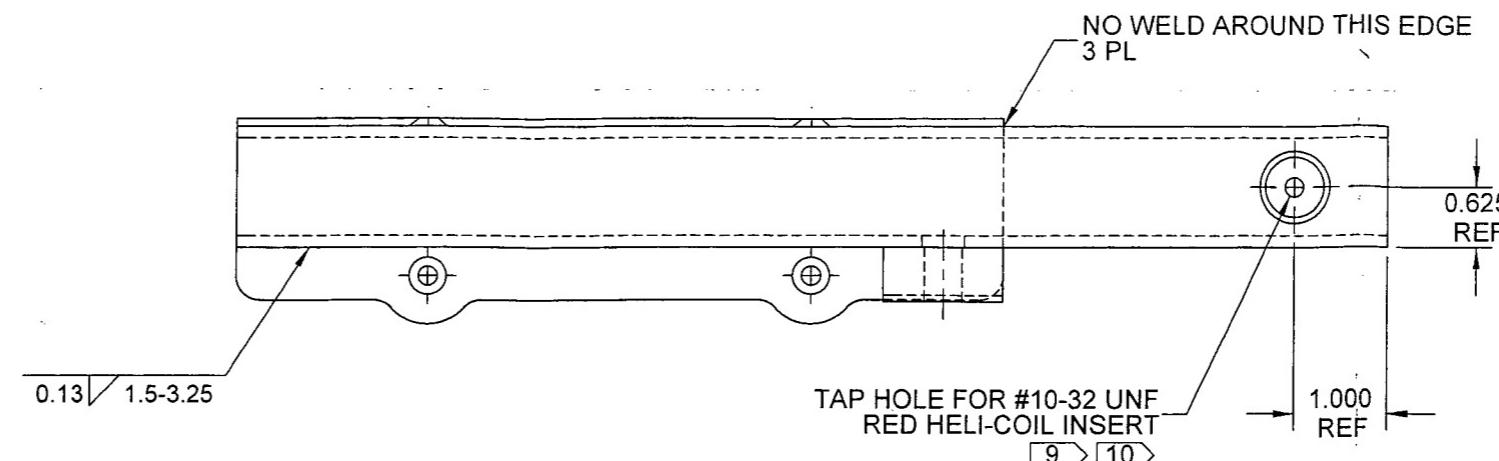
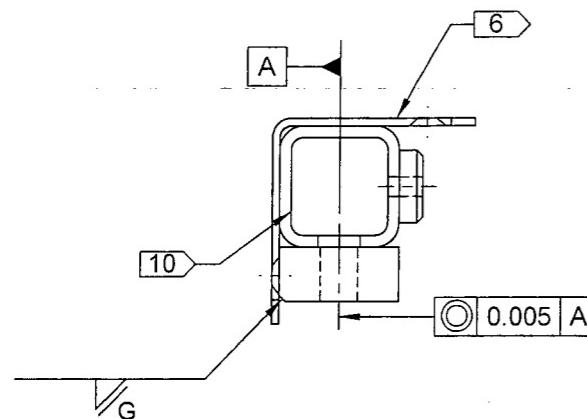
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.89 lbs
- 8) WELD PER DART QSI 004

DESIGN	14	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	14	
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3785
DE APPR.		SHEET 2 OF 4
DATE	08.04.29	TITLE ARMREST WELDMENT
		SCALE NTS
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8 7 6 5 4 3 2 1

D

D



D3785-041 ARMREST WELDMENT WELDING DETAIL

PROTOTYPE
PLEASE RETURN ALL DRAWN
DATA TO ENGINEERING
08.06.07

D3785-041 NOTES:

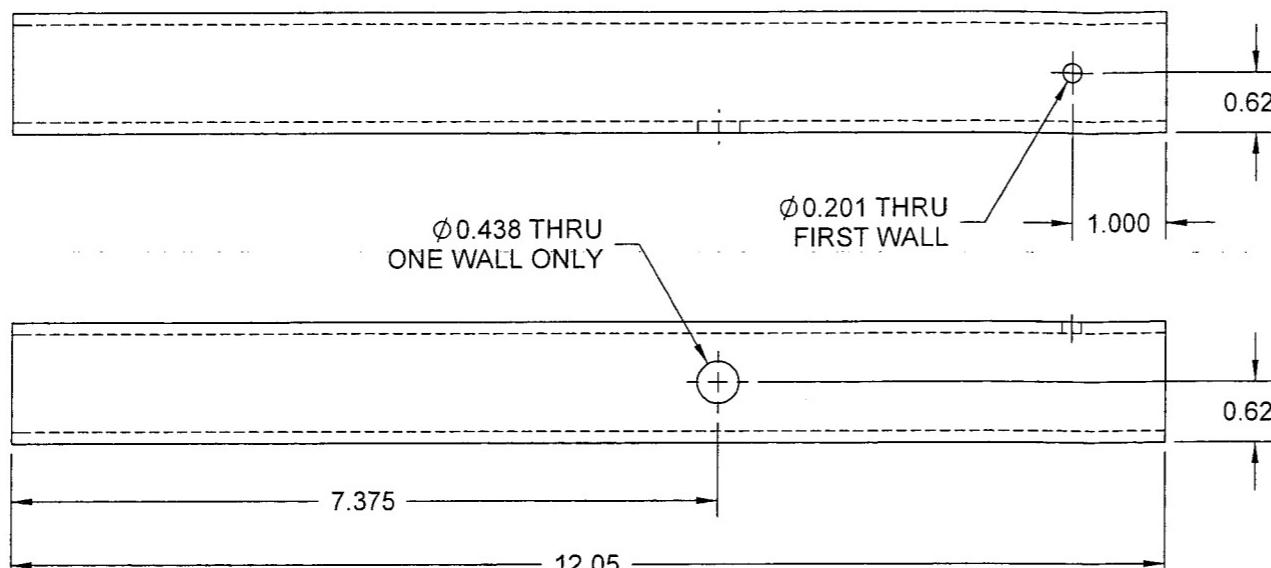
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004
- 9) TAP HOLE AFTER WELDING
- 10) MASK INSIDE OF TUBE AND THREADED HOLES PRIOR TO PAINTING

DESIGN	<i>1/2</i>	DART AEROSPACE LTD
DRAWN	<i>1/2</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>1/2</i>	DRAWING NO.
MFG. APPR.	<i>1/2</i>	REV. A
APPROVED	<i>1/2</i>	D3785
DE APPR.	<i>1/2</i>	SHEET 2 OF 4
DATE	<i>08.04.29</i>	TITLE
		ARMREST WELDMENT
		NTS
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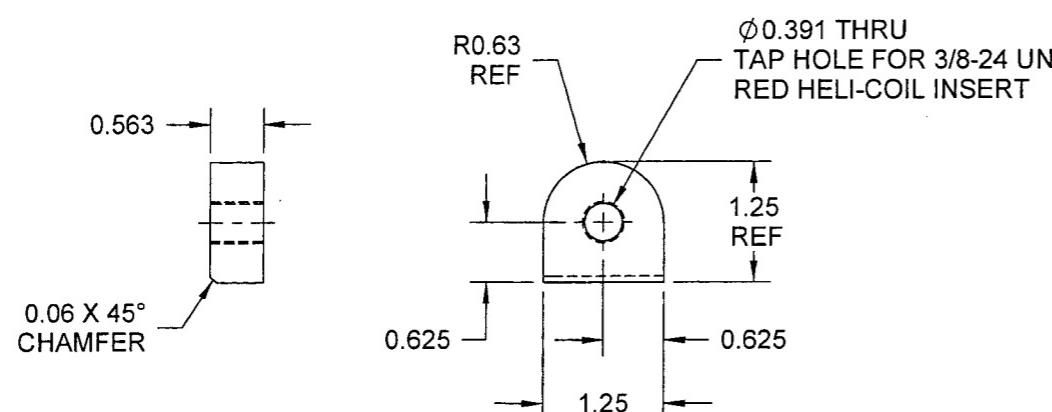
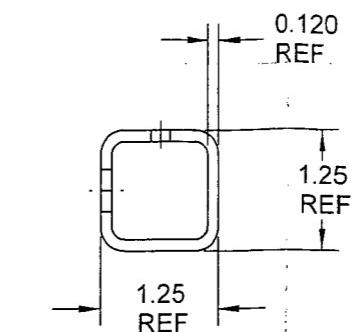
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A

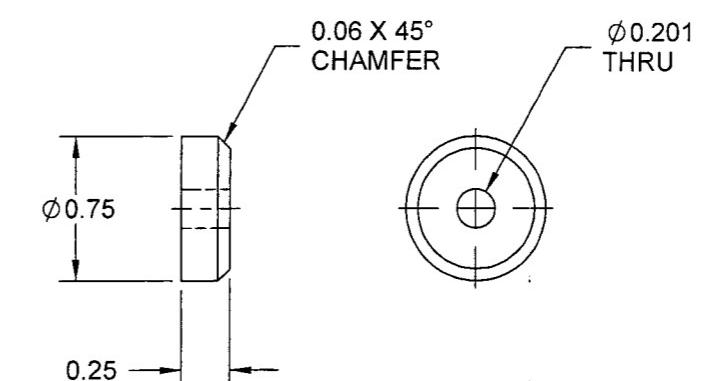
8 7 6 5 4 3 2 1



D3785-1 TUBE



D3785-5 FIXTURE



D3785-7 STOPPER

D3785-1/5/7 NOTES:

- 1) MATERIAL:
- D3785-1: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING, 1.25 X 1.25 X 0.120 WALL, PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.250W.120)
- D3785-5: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- D3785-7: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: - D3785-1 = 0.59 lbs
- D3785-5 = 0.07 lbs
- D3785-7 = 0.04 lbs

PROTOTYPE
PLEASE RETURN ALL I^ED DATA TO ENGINEER
15.06.05

DESIGN	<i>[initial]</i>	DART AEROSPACE LTD	
DRAWN	<i>[initial]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[initial]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[initial]</i>	D3785	SHEET 3 OF 4
APPROVED	<i>[initial]</i>	TITLE	SCALE
DE APPR.	<i>[initial]</i>	ARMREST WELDMENT	NTS
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